

**AMENDMENTS TO THE CLAIMS**

The following listing of claims will replace all prior versions and listings of claims in the application.

**LISTING OF CLAIMS**

- 1.- 15. (Cancelled)
16. (Previously Presented) A workpiece produced by the process, comprising:  
introducing casting cores into a casting cavity; and  
producing passages from the casting cores, which pass through the workpiece, wherein the casting cores are introduced into the casting cavity in such a manner that they rest loosely against one another.
17. (Currently Amended) The workpiece as claimed in claim 16, wherein the casting cores introduced into the casting ~~activity~~cavity are subsequently coated with a material which can withstand casting and bonds to them.
- 18.-20. (Cancelled)
21. (Previously Presented) A workpiece as claimed in claim 16, wherein the workpiece is an internally cooled turbine blade.
22. (Previously Presented) A workpiece as claimed in claim 16, wherein the workpiece is an internally cooled turbine vane.

23. (Previously Presented) A workpiece as claimed in claim 17, wherein the workpiece is an internally cooled turbine blade.
24. (Previously Presented) A workpiece as claimed in claim 17, wherein the workpiece is an internally cooled turbine vane.
25. (Previously Presented) A workpiece as claimed in claim 16, wherein the passages pass through the workpiece in the form of a three-dimensional grid.
26. (Previously Presented) The workpiece as claimed in claim 16, wherein passage openings have diameters of between approximately 0.1 and approximately 2 mm.
27. (Currently Amended) A ~~casted~~cast workpiece, comprising:  
a wall including passages in the form of a three-dimensional grid, whereby a ~~casted~~cast three-dimensional grid coating of the passages is one piece with the remainder of the workpiece.
28. (Previously Presented) The workpiece as claimed in claim 27, wherein practically a quarter of the total area of a workpiece side is made up by an area of uniformly distributed passage openings.
29. (Previously Presented) A workpiece as claimed in claim 27, wherein the workpiece is an internally cooled turbine blade.

30. (Previously Presented) A workpiece as claimed in claim 27, wherein the workpiece is an internally cooled turbine vane.
31. (Previously Presented) A workpiece as claimed in claim 28, wherein the workpiece is an internally cooled turbine blade.
32. (Previously Presented) A workpiece as claimed in claim 28, wherein the workpiece is an internally cooled turbine vane.
33. (Previously Presented) The workpiece as claimed in claim 27, wherein passage openings have diameters of between approximately 0.1 and approximately 2 mm.
34. (Previously Presented) The workpiece as claimed in claim 28, wherein passage openings have diameters of between approximately 0.1 and approximately 2 mm.
35. (New) A workpiece produced by a process, comprising:  
introducing casting cores into a casting cavity;  
drawing a casting material into the casting cavity to ensure that all surfaces of the casting cores and all regions of the casting mold are filled with the casting material; and  
producing passages, having non-uniform lengths and branches, from the casting cores, which pass through the workpiece, wherein the casting cores are introduced into the casting cavity in such a manner that they rest loosely against one another.

36. (New) A workpiece produced by the process, comprising:  
introducing casting cores into a casting cavity; and  
producing passages from the casting cores, which pass through the workpiece, wherein the casting cores are introduced into the casting cavity in such a manner that they rest loosely against one another and all of the casting cores have substantially the same size.

37. (New) A workpiece produced by the process, comprising:  
introducing casting cores into a casting cavity; and  
producing passages from the casting cores, which pass through the workpiece, wherein the casting cores are introduced into the casting cavity in such a manner that they rest loosely against one another and wherein the casting cores are randomly distributed inside the casting cavity.